

Low carbon martensitic or low carbon dual phase (ferrite plus martensite) stainless steel containing 10.5 to 14% chromium content by weight.

11

Trim Edges of Plate or Coil to Remove Surplus Width, Edge Cracks and Insure all Oxide is removed.

13

Form Plate or Coil through Continuous Roll Forming Mill

16

Autogenous Electric Resistance Weld with Induction High Frequency Welder

19

Remove Internal and External Squeeze Weld Bead

22

Optional Post Welding Heat Treat of the Weld Seam and Adjacent HAZ or Full Body of the Pipe

25

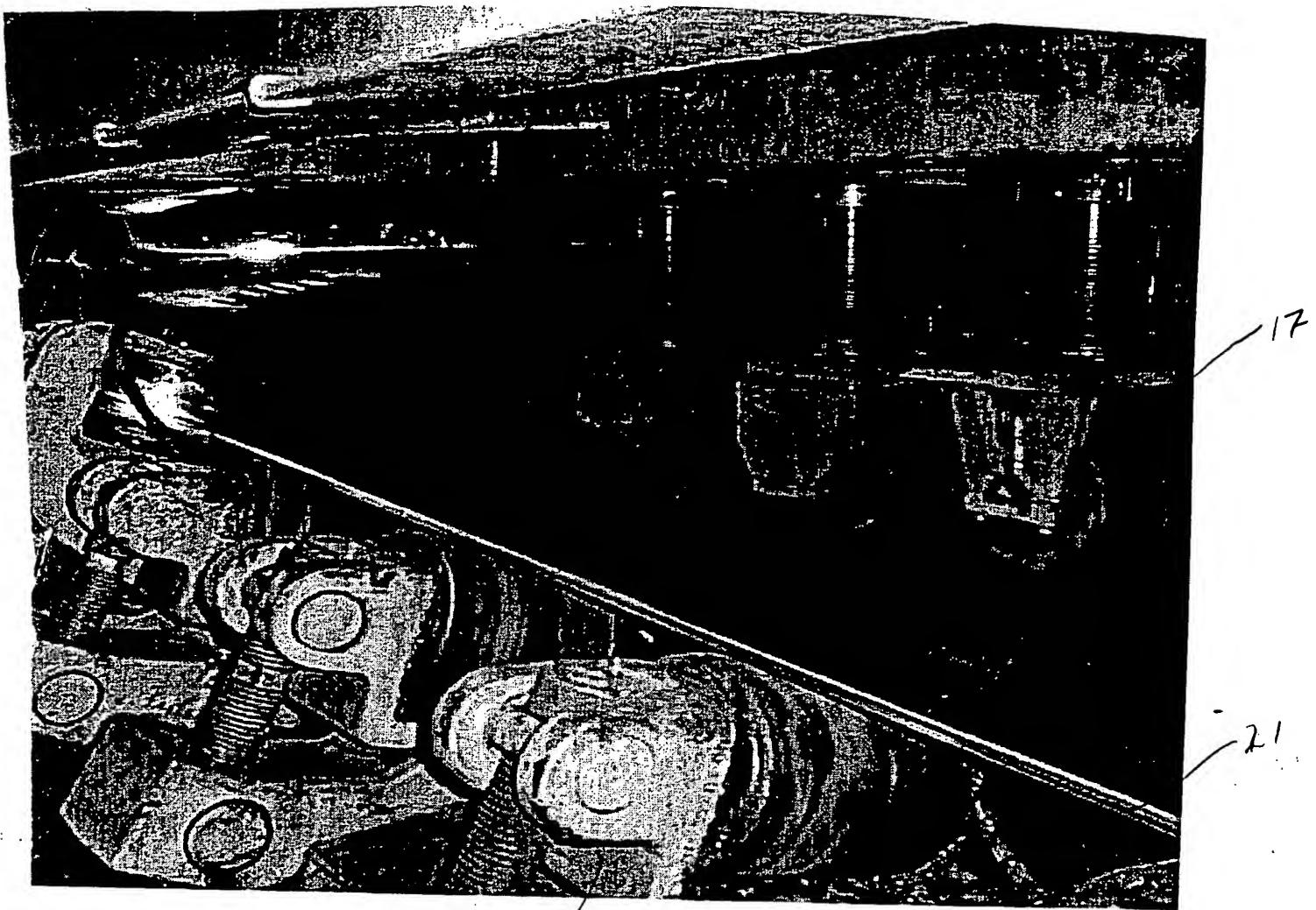
Ultrasonic or Electro Magnetic Inspection of the Weld Line or of the Weld Line and the Full Body of the Finished Pipe

30

Finished Dual Phase or Martensitic Stainless Steel Pipe

32

FIGURE ONE



19
FIG. 2

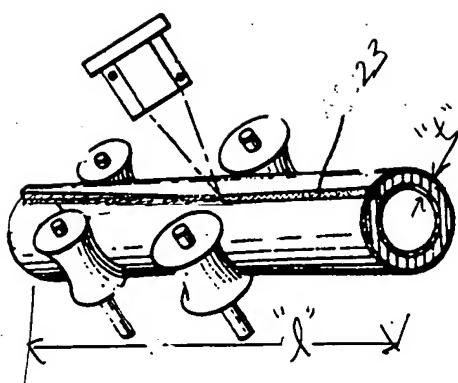
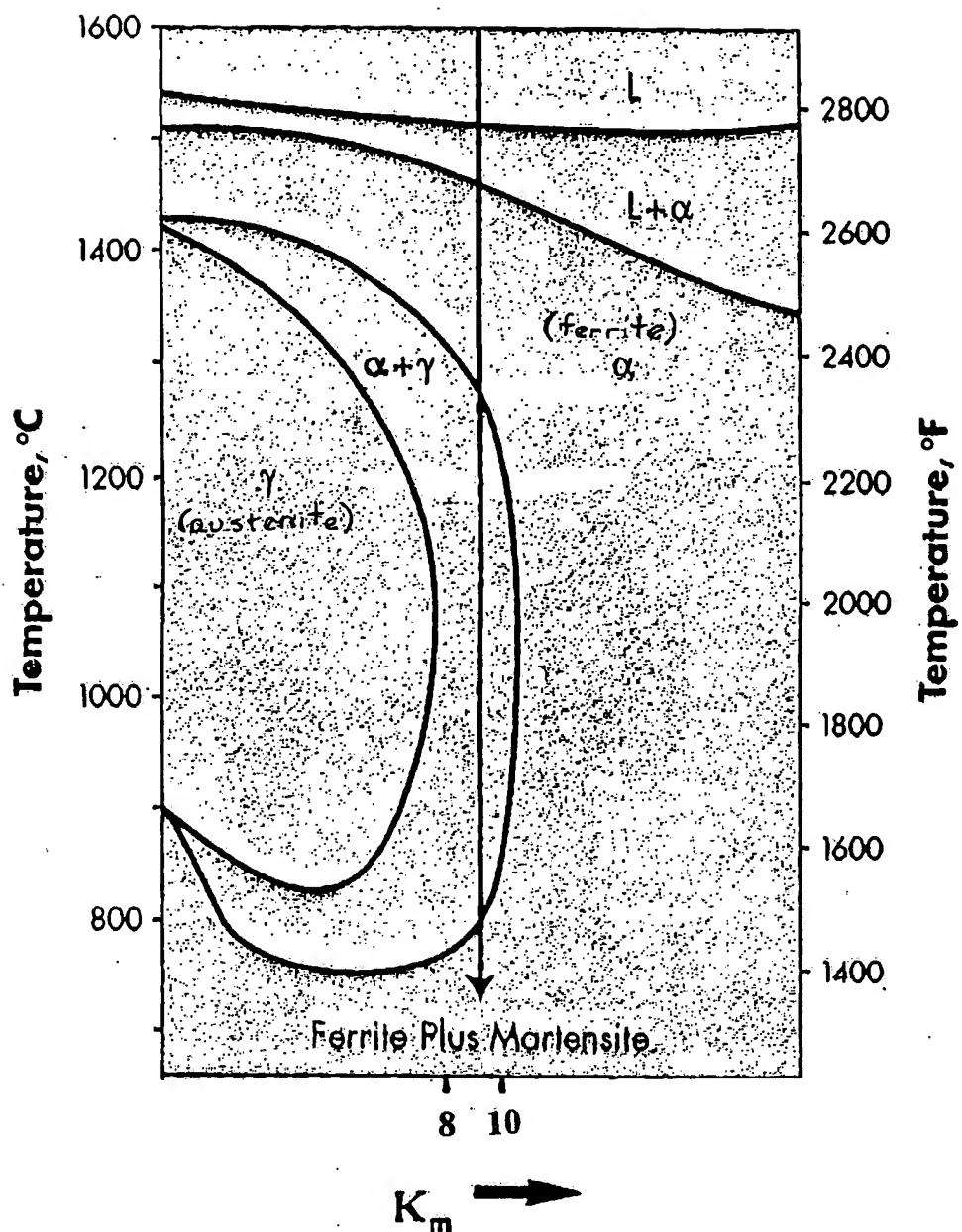


FIG. 3



Chemical Balance For Dual Phase Microstructure

$$K_m = Cr + 6 Si + 8 Ti + 4 Mo + 2 Al - 2 Mn \\ - 4 Ni - 40 (C+N) - 20 P - 5 Cu$$

Figure 4